

Work Order ID 56070

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Item ID: D119-755-014

Accept

Setup Start

Revision ID:

Stop

Item Name: Bubble Window, RH

Start Date: 2/09/10 Start Qty: 2.00

Required Date: 2/12/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

U/R

Rev U/R

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-755-014 CHG 001

8/10/02/11

8/10/02/11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-2-10

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/02/11

62

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Item ID: D119-755-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Bubble Window, RH

Start Date: 2/09/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-755-014

Location:

PPP Rev:

A FG051

10-2-11 SP 2X

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/02/11

U 10-02-11

Picklist Print

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Work Order ID: 56070

Parent Item: D119-755-014

Parent Item Name: Bubble Window, RH

Comments: IPP A New Issue 6/28/2007 DL
IPP B Dwg. Update 4/25/2008 DL verified by:DD

Start Date: 2/09/10

Required Date: 2/12/10

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3624-2 | | Manufactured | No | | | 110 | Each | 0.0000 | 2.0000 | | | |



Bubble Window

D2126 x1 @ 85" long. Manufactured No



Seal

5102411
B massed 8102411 x2

Warehouse

Location

Main Warehouse

ST

48285

Loc Qty

213.3334

213.3334

110

Each

Loc Code

7.0000

2.0000

D3561-1



Seal Insert Tool

Warehouse

Location

Main Warehouse

ST

45778

Loc Qty

7

7

Loc Code

B560H 10-2-11 SP

10-2-11 SP

2
10-2-11 SP

2

52.4 Re-Installation of D119-755-014 Bubble Window Kit

- 52.4.1 At the customer's option, remove RH crew door (109-0360-01-164 or equivalent) from the aircraft per the Aircraft Maintenance Manual to facilitate window installation.
- 52.4.2 Remove any existing window per the Aircraft Maintenance Manual or applicable instructions.
- 52.4.3 Install the D3624-2 Bubble Window in the doorframe using D2126-0850 Seal as shown in Figure 52-1. Before actually installing the window, verify that there is at least 0.30" (7.6mm) of overlap between the window and the door frame along the straight edges of the window and at least 0.12" (3.0mm) of overlap along the radius of the corners. The recommended procedure is to install the seal onto the door and then to install the window into the seal. Trim the ends of the seal as required. Seal ends should meet at the 6 o'clock position with a maximum gap of 0.125" (3.2mm). If a gap exists, it should be filled with Proseal or PRC. The included D3561-1 Seal Insert Tool can be used to assist in working the seal around the window. If necessary, it is acceptable to trim the window to improve the fit as long as the minimum overlap values are maintained.
- 52.4.4 If the crew door was previously removed, re-install modified crew door on the aircraft per the Aircraft Maintenance Manual.
- 52.4.5 Verify proper closing, sealing, and latching of the door.
- 52.4.6 Note: To increase downward viewing clarity, it is acceptable to cut a small section from the bubble window on its downward side. The cut-out can be a maximum of 5.25" wide x 13.50" long (133mm x 343mm), measured along the profile of the bubble window. The corners of the cut-out must have a minimum radius of 2" (50mm). The cut-out should be located within 1.0" to 1.5" (25mm to 38mm) of the bubble flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 52-2 for reference.

52.5 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|--|------------------|---------------------|--------------------------|-----------------|-----------------------|
| | | Arm | Moment | Arm | Moment |
| D119-755-011 Crew Door Window Kit, LH / RH | 3.5 lb 1.6 kg | ±27.6 in ±0.70 m | ±97 in-lb ±1.12 m-kg | 63 in 1.60 m | 220 in-lb 2.6 m-kg |
| D119-755-014 Bubble Window Kit, RH | 4.5 lb 2.0 kg | +31.6 in +0.80 m | +142 in-lb +1.60 m-kg | 63 in 1.60 m | 284 in-lb 2.6 m-kg |

52.6 PARTS LIST

| Qty -011 | Qty -014 | Part Number | Description |
|-------------|-------------|--------------|-------------------------------------|
| X | | D119-755-011 | CREW DOOR WINDOW KIT (FITS LH & RH) |
| | X | D119-755-014 | BUBBLE WINDOW KIT, RH |
| 1 | 1 | D2126-0850 | SEAL |
| 1 | | D3623-1 | WINDOW |
| | 1 | D3624-2 | BUBBLE WINDOW |
| 1 | 1 | *D3561-1 | SEAL INSERT TOOL |

* Not part of the -011/-014 installations, tool only

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries